

Fig. 1a

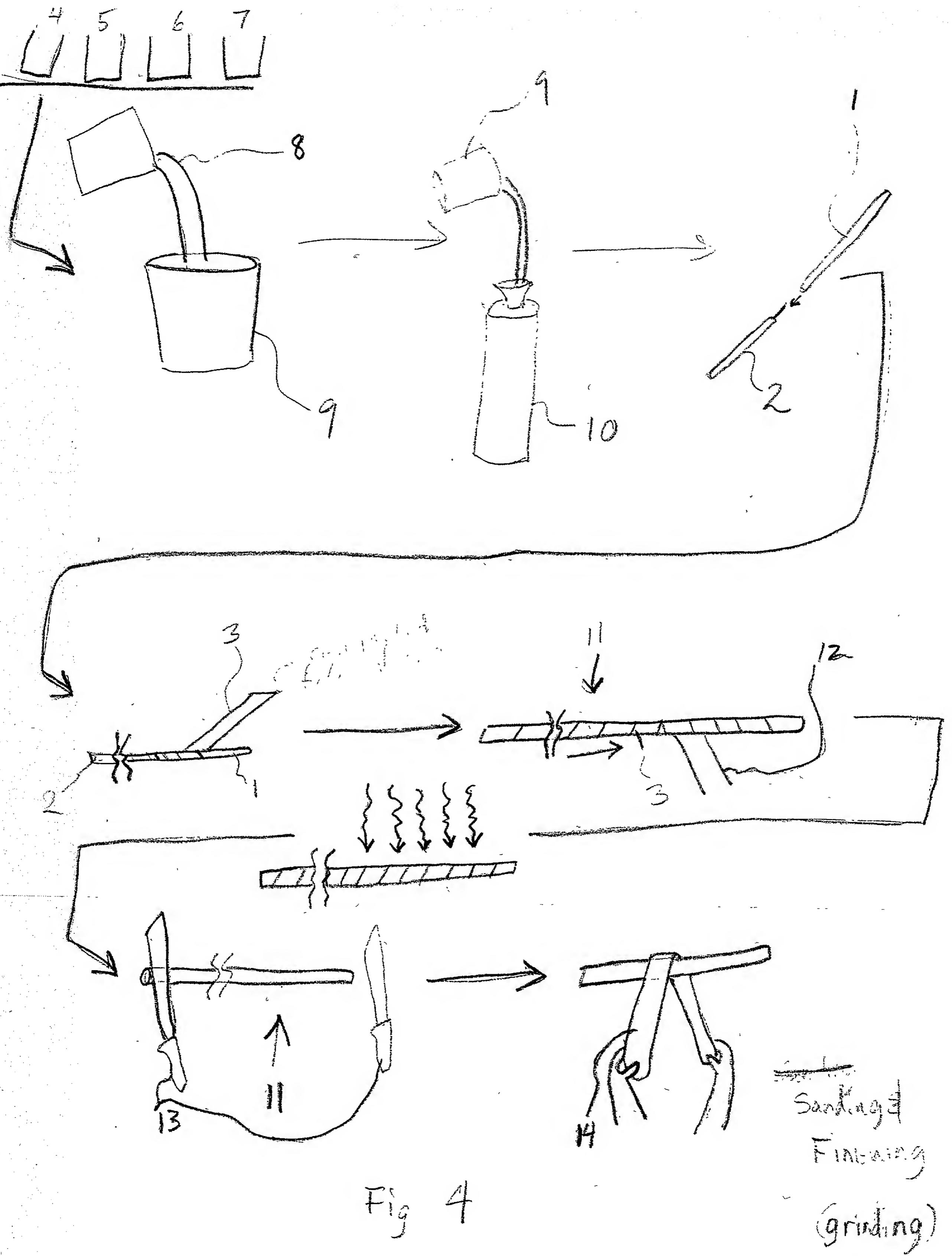


Fig 4

Sand casting  
 Finishing  
 (grinding)

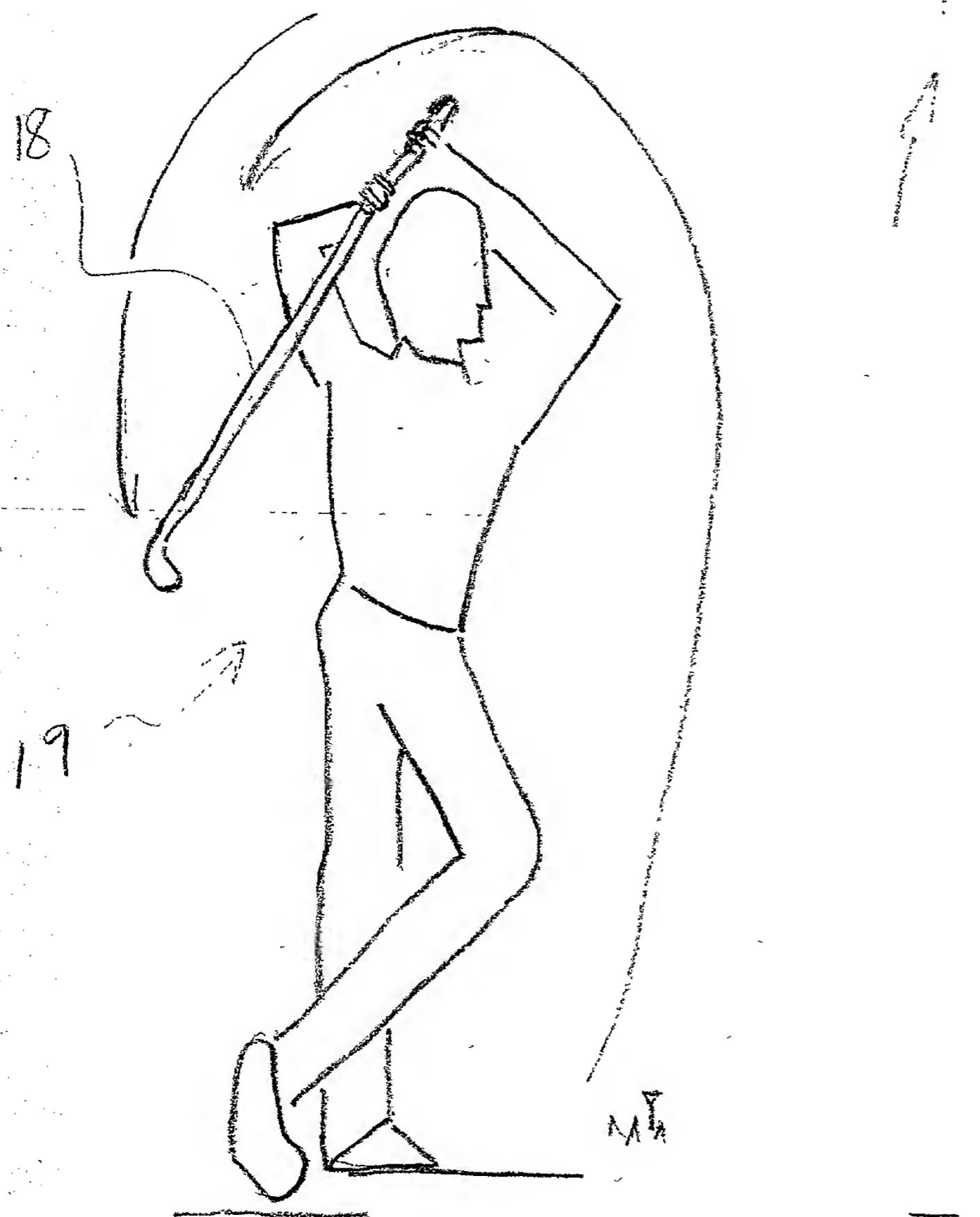
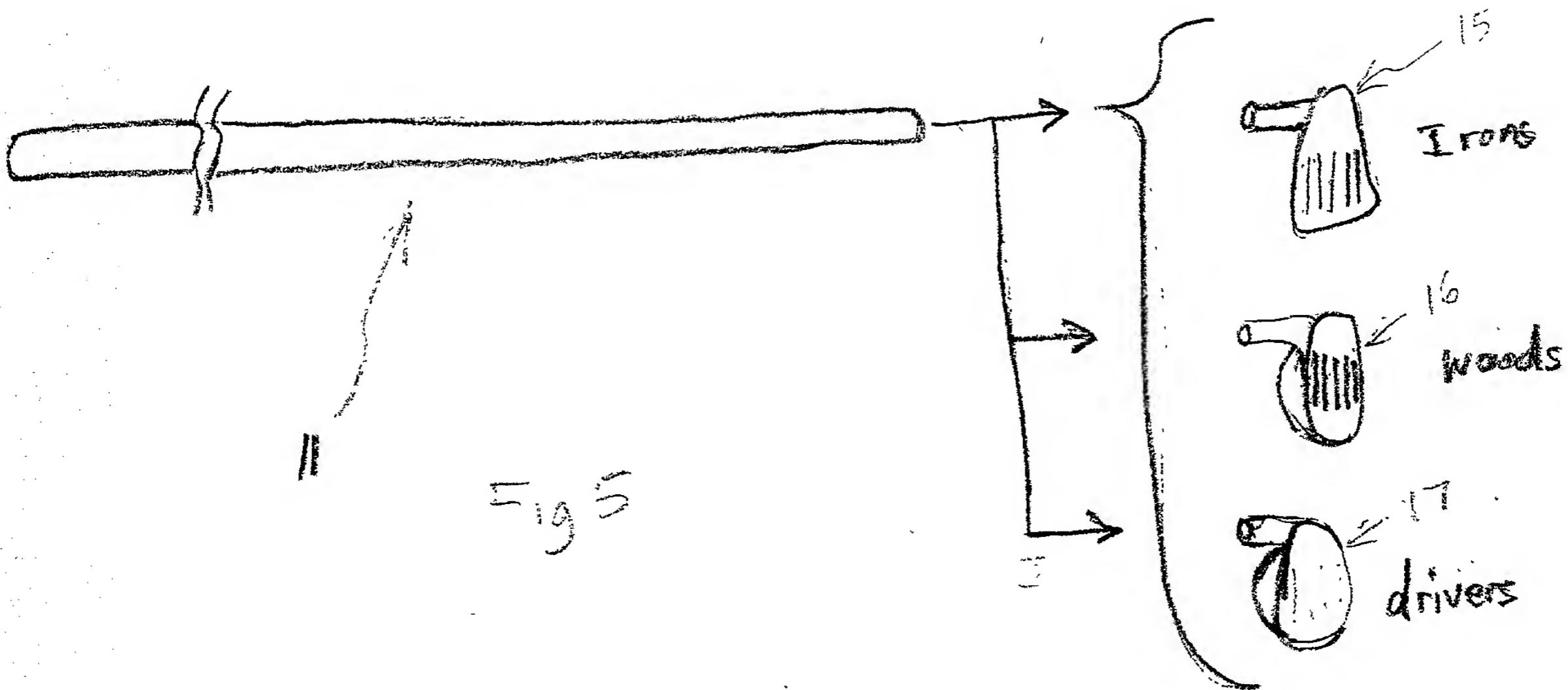


Figure 6

